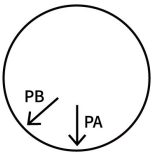


S-2594.16

Classification

AWS A5.4/ASME SFA-5.4 E2594-16
EN ISO 3581- A E 25 9 4 N L

Welding Positions



Features

- Service temperature up to 250°C
- High resistance to Pitting corrosion and embrittlement
- PREN 41
- Easy to remove slag, good bead appearance

Polarity

AC or DC+

Application Areas

- Welding of super duplex stainless steel (UNS S32750, S32760)

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N
0.02	0.75	0.7	0.018	0.010	0.05	9.5	25.2	3.8	0.23

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
927(134)	25	-20(0)	30(22)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux